



SECTION A - A

NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

* TOLERANCE DETERMINED BY VENDOR FOR E BEAM WELD OR VACUUM BRAZING REQUIREMENT

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED LOG NUMBER ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS ANGULAR X .03 (.7620) .25 ° XX .01 (.254) XXX .005 (.127)		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DESIGNER SHU/MUSCIA		DATE 3/24/00	CHIEF DESIGN ENGINEER D. SHU	DATE 3/24/00
CHECKED BY D. SHU			GP LEADER P. DEN HARTOG	
DESIGNER SHU/MUSCIA		DATE 3/24/00	PROJECT MGR.	
RESPONSIBLE ENGINEER D. SHU			APPROVE D/RELEASED	
MATERIAL SST 304 9" O.D. X .625 WALL		SCALE HALF SIZE SHEET 1 of 1 C		
DRAWING NUMBER W1-720102-00		DRAWING NUMBER W1-720102-00		